

Date: Monday, 2/19/2007 3:26:57 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOOR PROTCTOR RH		
Job Number	: 30769		Part Number	: D32803		
Estimate Number	: 11225		Drawing Number	: D3280 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 2/19/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 3/15/2007 Qty: 10 Um: Each		
Previous Run	: 25748					
Written By						
Checked & Approved By						
Comment	: Est Rev. A 04.07.01 New issue KJ/JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>3136</u> <i>2/19/2007</i> (10) Description: Floor Protector RH Possible Supplier: Delastek Certificate of Conformity is required		
2.0	D32803P	Floor Protector, RH
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Floor Protector, RH		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

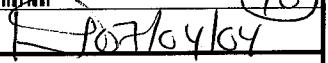
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/04/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOOR PROTCTOR RH
Job Number: 30769	Part Number: D32803	
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE		 10 07/04/04
Job Completion		
		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

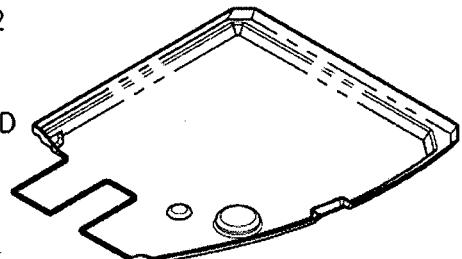
NOTE: Date & initial all entries

**DART**

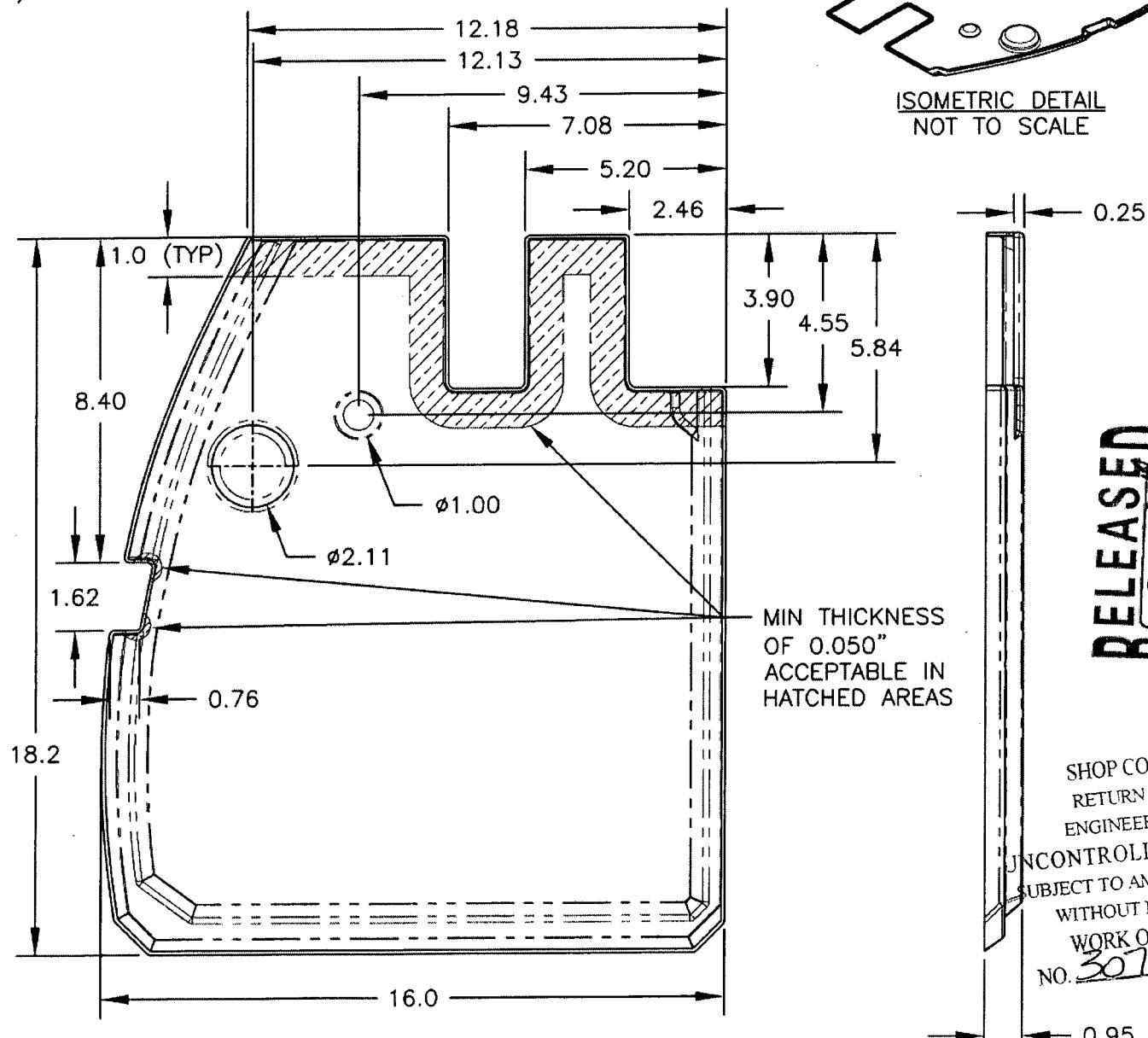
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3280
DATE		REV. B SHEET 1 OF 2
05.11.25		TITLE FLOOR PROTECTOR SCALE 1:4
A	04.04.05	NEW ISSUE
B	05.11.25	NOW LEXAN, DIMS AS MANUFACTURED

D3280-1 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-1T1, TRIM USING D3280-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN



ISOMETRIC DETAIL  
NOT TO SCALE



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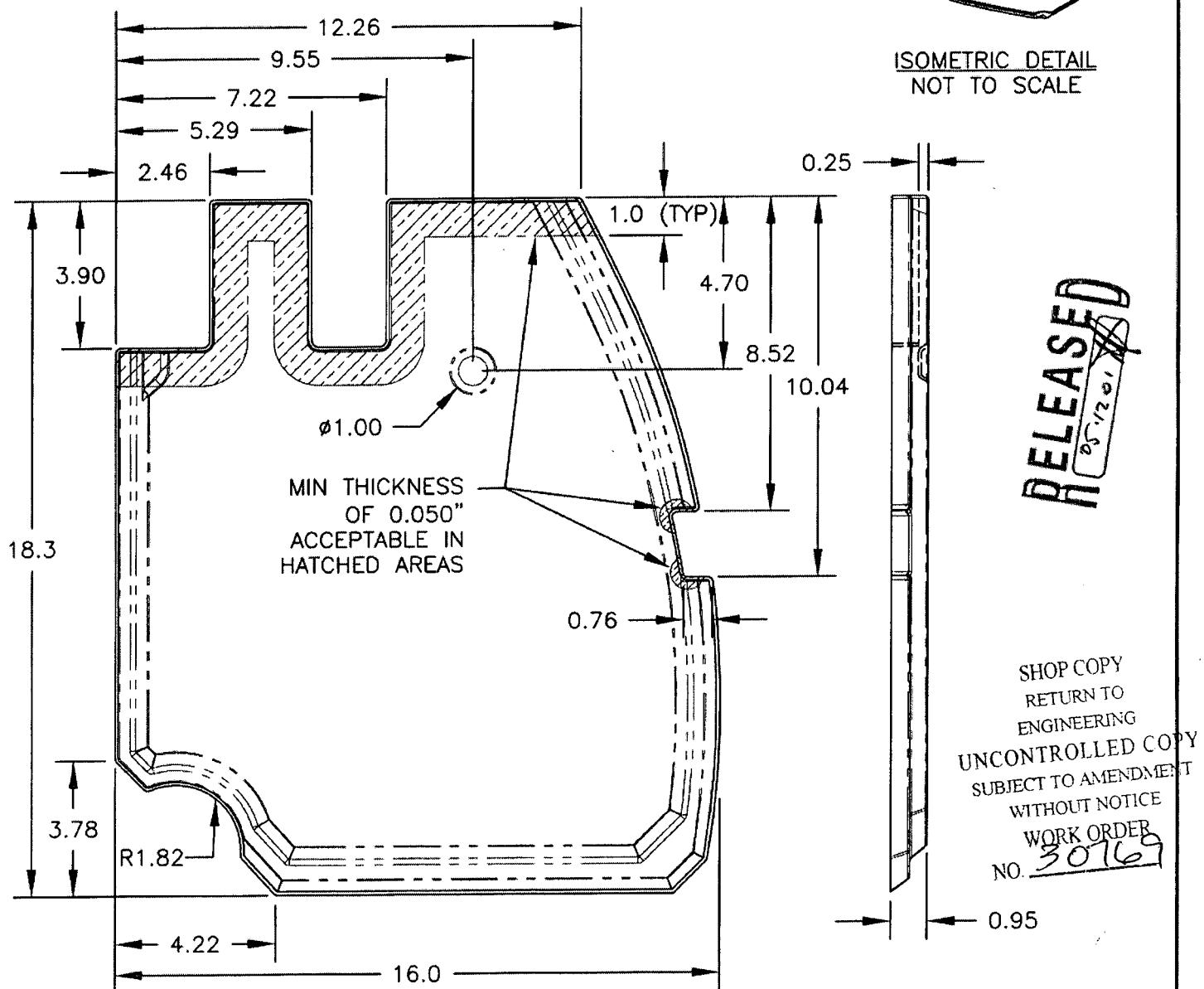
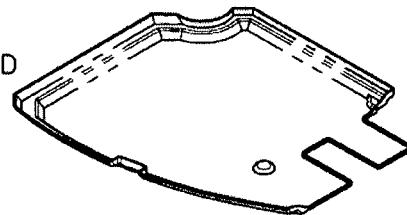
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3280
DATE		REV. B SHEET 2 OF 2 SCALE 1:4
05.11.25		TITLE FLOOR PROTECTION

### D3280-3 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-3T1, TRIM USING D3280-3T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080 EXCEPT AS SHOWN



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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice #	11735
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #	
16/03/07	21/02/07	5175	C. Lavoie	PO00003136		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description		
10	0	10	DKC134-0048	Floor Protect LH N° D3280-1P ( F6006 ) Selon dessin D3180 Rev.: B  Dart Aerospace  JOB: 41080      QTÉ: 10		
10	0	10	DKC134-0049	Floor Protect RH N° D3280-3P ( F6006 ) Selon dessin D3180 Rev.: B  Dart Aerospace  JOB: 41081      QTÉ: 10		

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by



Cust.

Adm.

Quality

Ship.

Quality department

AQ-357

Date: Lundi, 2007-02-26 10:50:29  
Utilisateur: Sylvie Hamel

## Feuille de Procédé

Client : DART Dart Aerospace Ltd.  
 Numéro Job : 41081  
 Numéro Soumission : 2388  
 Numéro B.A. :  
 Cette fois : 2007-02-26 No. B.V. :  
 Prsht Rev. : NC  
 Prem. fois : - - Type :  
 Job précédente : 41069

Nom Dessin : FLOOR PROTECTOR  
 Numéro Article : DKC134-0049  
 Numéro Dessin : D3280  
 Projet Numéro : DKC134  
 Révision dessin : B  
 Matériel : F6006  
 Date Dûe : 2007-03-02

Qté: 12 UdM: UNITE

Écrit par :  
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce: D3280-3

10.03.07

Process Sheet Rév.: 00 Création du premier

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
Commentair Qty.: 0.167 UNITE(s)/Unit Total : 2.004 UNITE(s) Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.		
2.0	SÉCHAGE/ ANEAL	SÉCHAGE / ANEALING
Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.4000Hrs SÉCHAGE DU MATÉRIEL		
3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 36.0000Hrs

## TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.



Quantité: 1 Date: 6-3-07 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 41081

Numéro Article: DKC134-0049

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
4.0	THERMOFORMAGE2	THERMOFORMAGE DES PIÈCE DART
<b>Commentair</b> Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 2.0000Hrs <b>THERMOFORMAGE DES PIECES</b>  Faire le thermoformage du "Floor Protector" N° D3280-3 à l'aide du moule N° D3280-3T1 sur le thermoformeur 4' x 8'.		
Autocontrôle du lot de pièce thermoformées.  Quantité: <u>12</u> Date: <u>14-3-07</u> Sceau: <u>EP</u>		
Quantité: _____ Date: _____ Sceau: _____		
5.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
<b>Commentair</b> Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 2.0000Hrs <b>TRIMAGE PLASTIQUE DART</b>  Faire le trimage du "Floor Protector" N° D3280-3 à l'aide du gabarit de trimage N° D3280-3T2.  Faire l'ébavurage des pièces.  Autocontrôle du lot de pièce trimées.  Quantité: <u>12</u> Date: <u>14-3-07</u> Sceau: <u>EP</u>		
Quantité: _____ Date: _____ Sceau: _____		
6.0	INSPECTION 3	INSPECTION PIÈCE DART
<b>Commentair</b> Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.0000Hrs <b>INSPECTION PIÈCE DART</b>  Faire l'inspection finale des pièces selon le dessin.  Quantité: <u>12</u> Date: <u>15/3/07</u> Sceau: <u>EP</u> <i>formateur n°8</i>		
7.0	IDENTIFICATION4	IDENTIFICATION PIÈCES DART
<b>Commentair</b> Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.0000Hrs <b>IDENTIFICATION PIÈCES DART</b>  Faire l'identification des pièces à l'aide des informations suivantes:		

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 41081

Numéro Article: DKC134-0049

Numéro Job:



# Séq.: Machine ou Opération: Description :

N° de pièce: D3280-3

N° de Job: 41081Date de fabrication: 14-3-07

Sceau d'inspection.

Quantité: 12 Date: 14-3-07 Sceau: CM

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

8.0 EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.0000Hrs

## EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3280-3

Date de fabrication: \_\_\_\_\_

N° de job: \_\_\_\_\_

Quantité: 12 Date: 15/3/07 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_